



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3710
Job Sheet 170465



Part No: 646.3710

Job Qty: 16 ea

Part Name: Doubler



JAN 17 2018

DAS
13
9-89

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Created By: Linda Lacelle

Due Date: 2/8/18

Type: AOG

Description:

Note: DWG REV A IPP REV:A 12.12.19 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	16 pcs		2/8/18	0.00	0.00	Purchasing		AT 18/03/18
120	Packaging	16 pcs		2/8/18	0.00	0.00	Packaging2		AT 18/03/18
130	QC	16 pcs		2/8/18	0.00	0.00	QC6		MAR 12 2018
190	Packaging	16 pcs		2/8/18	0.00	0.00	Packaging3-1		MAR 13 2018
200	QC21-SA	16 Ea		2/8/18	0.00	0.00	QC21		MAR 14 2018

Part Op 110 - Issue P/O: 035808 Manufacture as per dwg Possible supplier: SOUTHLAND FABRICATION
Descriptions: 190 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

JAN 17 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
110-Purchasing	646.3710P	16	0	0	0

Part Specifications

Specifications could not be found.

Plex 1/16/18 1:41 PM dart.lacelle.linda

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

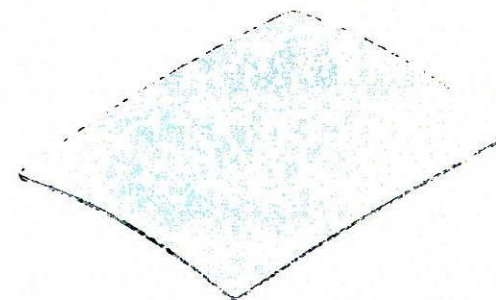
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																					
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																						
Large Fab ☐	Composite ☐	Supplier ☐																																																																							
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____																																																																					
Mtg Date: 03/09/18 Job No: 170465 PART NO: 646.3710 Serial No/Batch: S049669 Revision: _____ Operation: _____ Change No: _____ Packaging Doublor																																																																									
Root Cause <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">No Re-verification ☐</td> <td style="width:15%;"></td> <td style="width:15%;"></td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td></td> <td></td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td></td> <td></td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td></td> <td></td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td></td> <td></td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td></td> <td></td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td></td> <td></td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td></td> <td></td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td></td> <td></td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td></td> <td></td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td></td> <td></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td></td> <td></td> </tr> </table>				Environment ☐	No Re-verification ☐			Design ☐	Operator ☐			Doc/Data ☐	Offset/Setup ☐			Equip/Tooling ☐	Supplier ☐			Handling/Pre ☐	Training ☐			Material ☐	Use for Testing ☐			Internal Transport ☐	Poor Information ☐			Tribal Knowledge ☐	Rushing ☐			LOA ☐	Product Improvement ☐			Substation ☐	Process Improvement ☐			Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐			<table style="width:100%; border: none;"> <tr> <td style="width:15%;">☐ Positioned Wrong</td> <td style="width:15%;">☐ Out of Sequence</td> </tr> <tr> <td>☐ Outside Dimensions</td> <td>☐ Off-set</td> </tr> <tr> <td>☐ Over/Under tolerance</td> <td>☐ Mislabeled</td> </tr> <tr> <td>☐ Part Incorrect</td> <td>☐ Fit/Function</td> </tr> <tr> <td>☐ Part Lost/Missing</td> <td>☐ Misaligned/off center</td> </tr> <tr> <td>☐ Part Moved</td> <td></td> </tr> <tr> <td>☐ Drawing</td> <td></td> </tr> <tr> <td>☐ Finish</td> <td></td> </tr> <tr> <td>☐ Misread</td> <td></td> </tr> <tr> <td>☐ Turning Sequence</td> <td></td> </tr> </table>		☐ Positioned Wrong	☐ Out of Sequence	☐ Outside Dimensions	☐ Off-set	☐ Over/Under tolerance	☐ Mislabeled	☐ Part Incorrect	☐ Fit/Function	☐ Part Lost/Missing	☐ Misaligned/off center	☐ Part Moved		☐ Drawing		☐ Finish		☐ Misread		☐ Turning Sequence	
				Environment ☐	No Re-verification ☐																																																																				
Design ☐	Operator ☐																																																																								
Doc/Data ☐	Offset/Setup ☐																																																																								
Equip/Tooling ☐	Supplier ☐																																																																								
Handling/Pre ☐	Training ☐																																																																								
Material ☐	Use for Testing ☐																																																																								
Internal Transport ☐	Poor Information ☐																																																																								
Tribal Knowledge ☐	Rushing ☐																																																																								
LOA ☐	Product Improvement ☐																																																																								
Substation ☐	Process Improvement ☐																																																																								
Past Expiry Date ☐	Manufacturing Process ☐																																																																								
Misidentified ☐	Past Due ☐																																																																								
☐ Positioned Wrong	☐ Out of Sequence																																																																								
☐ Outside Dimensions	☐ Off-set																																																																								
☐ Over/Under tolerance	☐ Mislabeled																																																																								
☐ Part Incorrect	☐ Fit/Function																																																																								
☐ Part Lost/Missing	☐ Misaligned/off center																																																																								
☐ Part Moved																																																																									
☐ Drawing																																																																									
☐ Finish																																																																									
☐ Misread																																																																									
☐ Turning Sequence																																																																									
Heat Treat ☐ Countersink ☐ Wave/Twist in Tube ☐ Cut Too Short ☐ Marks/Chatter ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐																																																																									
OTHER : _____																																																																									

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES AND REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED

REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECN 03702		

NOTES:

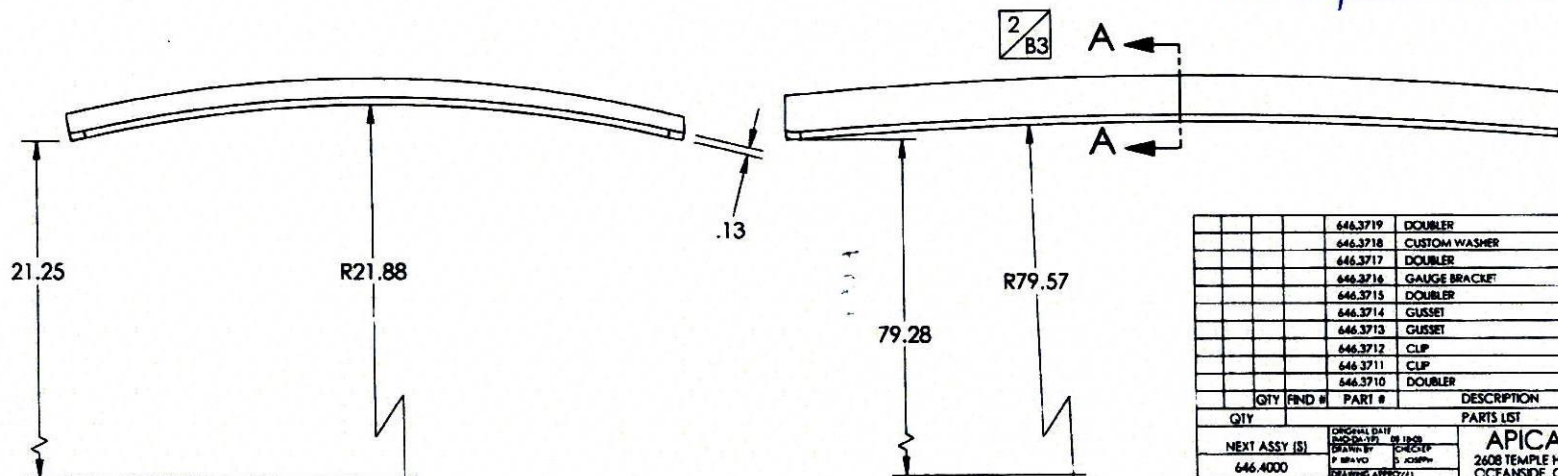
1. MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
3. MATERIAL: 17-4 PH AMS 5604, CONDITION H900
4. FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120



646.3710

UNINCORPORATED ECN(s)

03702

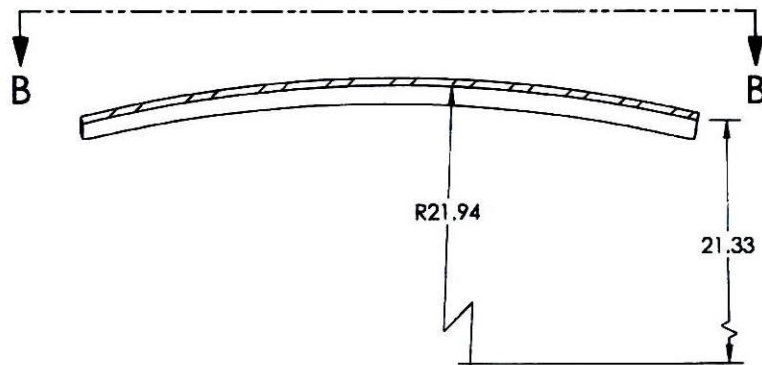


	646.3719	DOUBLER	▲	▲
	646.3718	CUSTOM WASHER	▲	▲
	646.3717	DOUBLER	▲	▲
	646.3716	GAUGE BRACKET	▲	▲
	646.3715	DOUBLER	▲	▲
	646.3714	GUSSET	▲	▲
	646.3713	GUSSET	▲	▲
	646.3712	CLIP	▲	▲
	646.3711	CLIP	▲	▲
	646.3710	DOUBLER	▲	▲
QTY	FIND #	PART #	DESCRIPTION	MATL SPEC

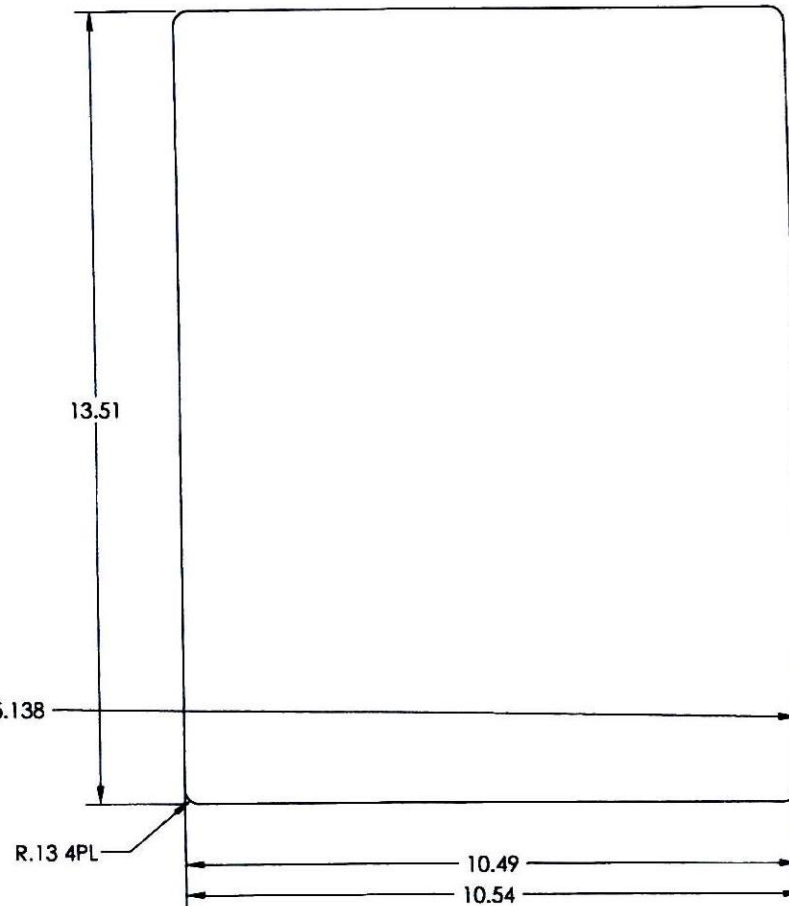
QTY	ORIGINAL DATE 6/1/98	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 SHEETMETAL
NEXT ASSY (S)	DESIGNED BY D. JOSEPH	
646.4000	APPROVED BY	
	DATE	
	CONTRACT NO.	

SHEET CODE B		DWG. NO. 646.3700	PP. A
SCALE NONE		SHEET 1	OF 2

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF
APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.



SECTION A-A



SECTION B-B

ORIGINAL DATE (MO-DA-YR) 08-18-08 DRAWN BY JC-SCOPPE P. SHAWO S. JOSEPH DRAWING APPROVAL J. JOSEPH 08-18-08 CONFLECT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ± 5°		SHEET 8 CAGE CODE 07M16 DWG. NO. 646.3700 SCALE NONE	PRTY A SHEET 2 OF 9



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO038808

Supplier: SOF001-VU
Southland Fabrication
353 Industrial Way
Fallbrook, CA 92028 USA
Phone: 760-723-4006
Fax: 760-723-4604

PO No: PO038808
PO Date: 1/17/18
Due Date: 2/14/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

E-MAILED
JAN 18 2018

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Part	Supplier Part No	Item No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	646.3710P			Doubler As Per Dwg 646.3700 Rev. A	Firmed	2/14/18	30 pcs	0 pcs	30 pcs	\$268.00/pcs	\$8,040.00
								30x	ATI 8/23/09		

Line Item Note job# 170465

Grand Total: \$8,040.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

[Handwritten signature]

Plex 1/17/18 11:46 AM dart.baker.diane

[Handwritten initials]

DAS
11
9-89



353 Industrial Way
Fallbrook, CA 92028
Ph: 760-723-4006

Certificate Of Compliance

Date : 03/02/2018

Job No. : 00017001

Customer : Dart Aerospace Ltd

P.O. Number : PO038808

Part Number : 646.3710 A

Quantity : 30

Description : Doubler

We hereby certify that all parts and/or material supplied by us have been produced in conformance with all contractually applicable purchaser's specification as referenced in the purchase order and/or drawing(s) supplied.



RoHS 2 Compliant to Directive 2011/65/EC

By:

D. Van Elk

Date:

3-2-18